

ASAP

Dart Aerospace Ltd.

Date: Friday, 12/7/2007 10:20:38 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : X-BOLT SPACER
Job Number : 36181	
Estimate Number : 13090	
P.O. Number : <i>N/A</i>	Part Number : D35045
This Issue : 12/7/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3504 REV C
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i>	Drawing Revision : C
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 12/14/2007
Checked & Approved By : <i>[Signature]</i> 07.12.07	Qty: <i>50</i> Um: Each
Comment : Est Rev A Rev C dwg 07-12-06 DD	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0750	6061-T6 Round Bar .750"
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Comment: Qty.: 0.0186 f(s)/Unit Total : 0.3717 f(s)

M6061T6R0.750

Batch: *1103155**19430 12"**22 07/12/11*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-TURN AS PER FOLIO FA712 &amp; DWG D3504,

FOLIO REV: *C*DWG REV: *C*

2-DEBURR AS REQUIRED

*22 07/12/11*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*22 07/12/11**(50)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*5.2 07/12/11*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *[Signature]**Barclay/Dan L.**(50)*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   D   Date: 07/12/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: X-BOLT SPACER

Job Number: 36181

Part Number: D35045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(50)

Comment: FINAL INSPECTION/W/O RELEASE

Done 12/13

Job Completion



Y 2007/12/12

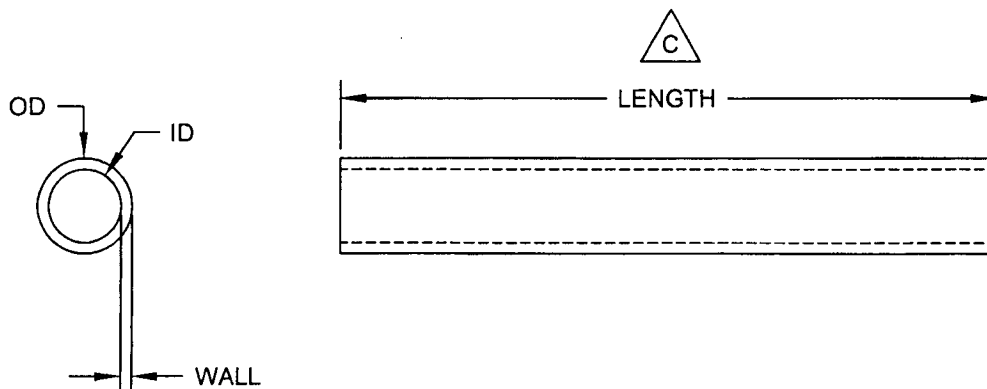
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



### D3504-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	LENGTH +0.030 -0.000	ID	MATERIAL SPEC	NOTE
D3504-1	0.500	0.049	3.475	0.402 (REF)	M6061T6T0.500W.049	SEE NOTE 1a)
D3504-3	0.375	0.049	3.475	0.277 (REF)	M6061T6T0.375W.049	SEE NOTE 1a)
D3504-5	0.750	0.080 (REF)	3.400	0.590	M6061T6R0.750	SEE NOTE 1b)

#### D3504-1/-3/-5 CROSS BOLT SPACER:

- 1) MATERIAL: a) 6061-T6 OR 6061-T62 TUBING  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082  
OR QQ-A-200/8 OR QQ-A-225/8  
(REF. DART SPEC. M6061T6TD.DDDW.TTT)
- b) 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6R0.750)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 36181  
**RELEASED**  
07.11.16

C	ADD -5	DC	07.09.19
B	3.475 WAS 3.400	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3504	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	CROSS BOLT SPACER	NTS
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

